



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-2
Job Sheet 173786



Part No: SWA6A-2

Job Qty: 1 ea

Part Name: Electric Swivel 6,000 lb Safe Work Load (2,721 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA6A-2 Rev4 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/8/18		0.00	0.00	Start Up Small Fab-2		SP
110	Small Fab	1 pcs	3/9/18		0.00	2.00	Small Fab-6		AP
120	QC	1 pcs	3/9/18		0.00	0.00	QC5		38
125	DC	1 pcs	3/9/18		0.00	0.00	DC		J-89
130	Packaging	1 pcs	3/9/18		0.00	0.00	Packaging3		DAS
140	QC21-FG	1 Ea	3/9/18		0.00	0.00	QC21		21 MAR 15 2018

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

125 - Photocopy blue file OM & OOPM-SWA6A Rev2

130 - Bag and tag

ACTITE 242 M138762 / SAF-T-EZE MGBT-16 → M128063 / SILICONE M138763

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA6A-800A	Connector Bushing	1 Ea (1 ea)	90-Start up Operation	5031156
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	110-Small Fab	5037083
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	110-Small Fab	5027240
C45-15-13	Sleeve	1 pcs (1 ea)	110-Small Fab	5029310
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5027230
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5024372
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	5029542 50417767
N13000-300 SPP MA	Circlip Internal	1 (1 ea)	110-Small Fab	
SWA6A-100	Lower End	1 Ea (1 ea)	110-Small Fab	5032354
SWA6A-1100	Upper Bearing	1 Ea (1 ea)	110-Small Fab	5029456 5040726
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5044605
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5040328
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	110-Small Fab	5045017
SWA6A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5040978
SWA6A-1900	Female Spade Terminal - 1/4"	4 Ea (4 ea)	110-Small Fab	5047603 5027243
SWA6A-200	Upper End	1 Ea (1 ea)	110-Small Fab	5032403
SWA6A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5040760
SWA6A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5035446
SWA6A-500	Semi Rings	1 Ea (1 ea)	110-Small Fab	5035127
SWA6A-600	Collar	1 Ea (1 ea)	110-Small Fab	5034731
SWA6A-700	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5029417

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	SWA6A-800A	1	34	0
110-Small Fab	188-FPSS-1032-5/8	1	396	0
	188-FSCS-1032-5/8	4	176	0
	C45-15-13	1	0	0
	EL-PLUG-F	1	38	0
	EL-PLUG-M	1	35	0
	EL314-SJTOW	6	1,181	0
	N13000 300 SPP	1	0	0
	SWA6A-100	1	10	0
	SWA6A-1100	1	9	0
	SWA6A-1200	1	39	0
	SWA6A-1300	1	19	0
	SWA6A-1400	1	9	0
	SWA6A-1800	1	10	0
	SWA6A-1900	4	64	0
	SWA6A-200	1	8	0
	SWA6A-300	1	9	0
	SWA6A-400	1	9	0
	SWA6A-500	1	9	0
	SWA6A-600	1	9	0
	SWA6A-700	2	32	0
	SWA6A-900A	1	0	0



Container No: S048762



Part: SWA6A-2

Job No: 173786

Serial No/Batch: S048762

Revision: 4

Inspector:

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Plex 3/7/18 10:31 AM Dart.lajeunesse.marie

Date: 03/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : 					



Electric Swivel
SWA6A

Work Order 173786

Customer _____

Number of Wires 2

Date 3 mar 2018

Serial Number 504862

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- Pass
1	6,000	Check all wires for grounding against swivel body.	- Pass
1	3,000	Check for Conductivity against all wires.	- Pass
1	3,000	Check all wires for grounding against swivel body.	- Pass
1	1,500	Check for Conductivity against all wires.	- Pass
1	1,500	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By:

Matthew Leikin

Technician

Signature:

Al Dauter

Director of Quality Assurance

DAS
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9-89

Submit